

5/12

DART AEROSPACE LTD		Work Order:	22784
Description: 206 L/L-1/L-3/L-4 HighGear Web		Part Number:	D2654-7
Drawing: D2654 Rev. DEI ^{04.08.17} 04.08.17 ^{04.08.17}		Qty:	2

Step	Location	Procedure	By	Date	QTY
1	EXPEDITING	Issue Work Order	JP	05.03.21	(2)
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 Web B21130	DP	05-3-23	(2)
3	METAL	Cut D2600-7 to length as per Dwg D2654 (116.00") 04.07.27 ^{04.07.27}	DP	05-3-23	(2)
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	DP	05-3-23	(2)
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	DP	05-3-23	(2)
6	METAL	Deburr holes and ends	DP	05-3-23	(2)
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	DP	05-3-30	(2)
8	QC	Inspect Level 5	2	05-03-30	2
9	METAL	Identify and stock	DP	05/3/30	(2)
10	EXPEDITING	Close Work Order Cost/part: 41.14 ^{46.38} 41.14 ^{05/04/01} (2)	JP	05.04.05	(2)

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	(S)

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
DM 99.02.19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

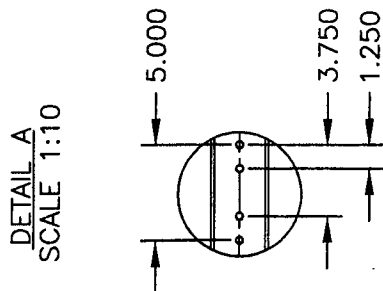
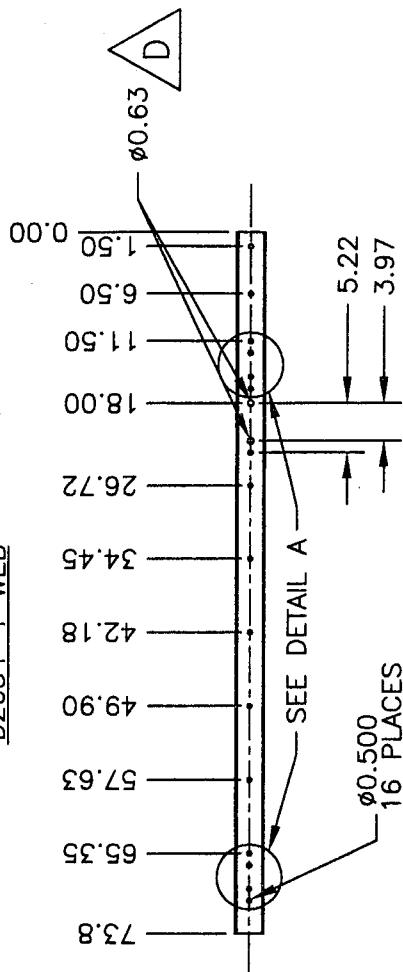
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

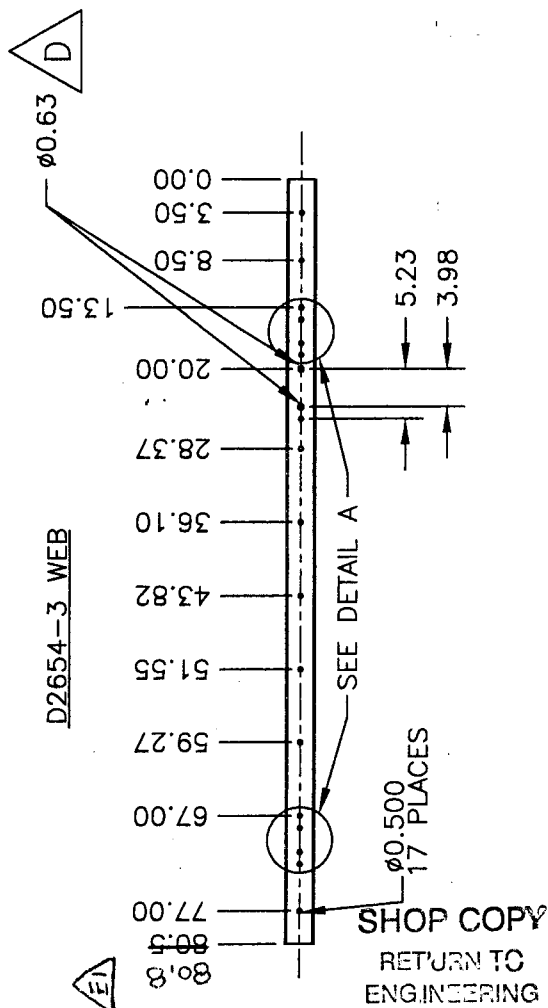
RELEASED
04.06.22

D2654-1 WEB



DETAIL A
SCALE 1:10

D2654-3 WEB



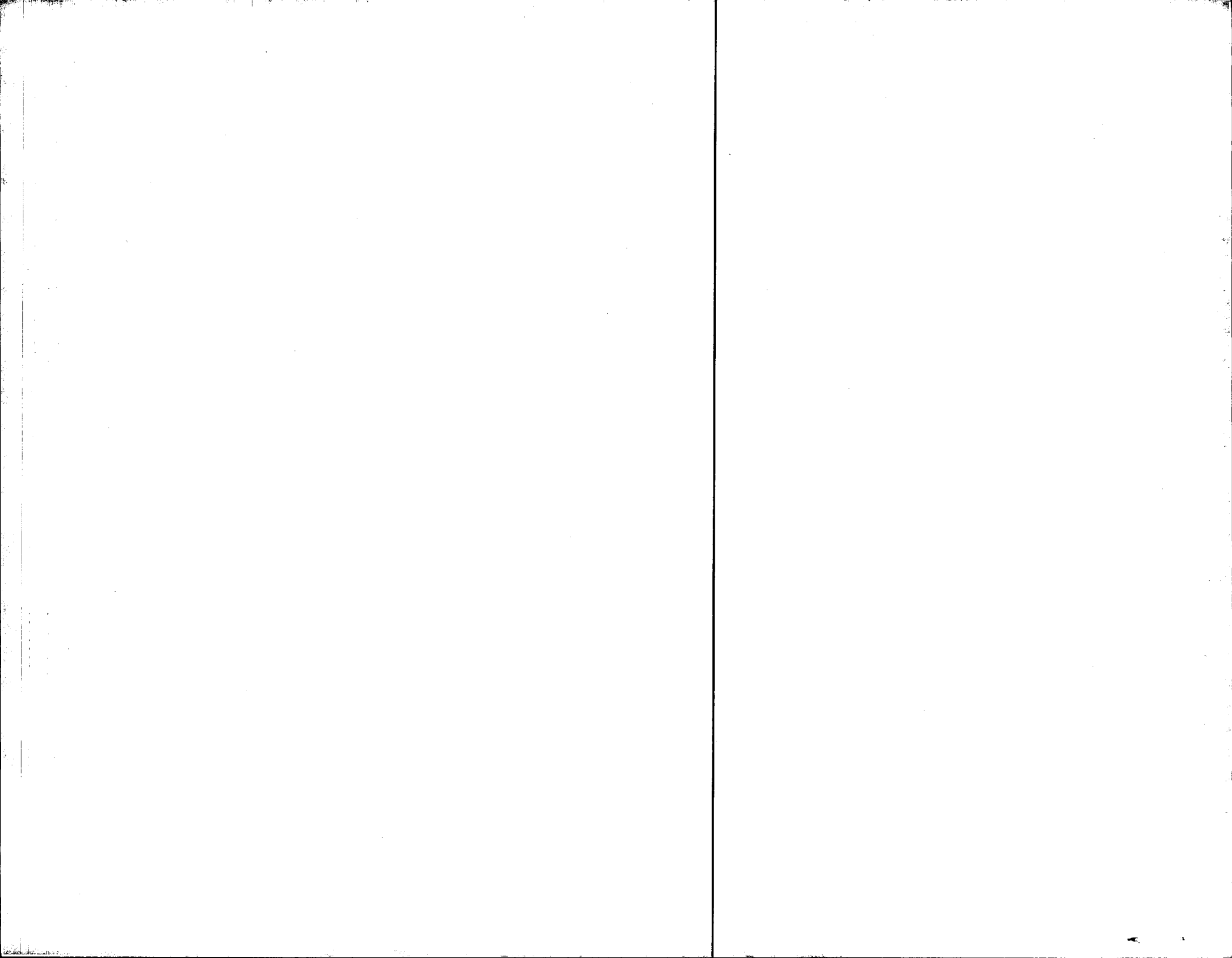
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WORK ORDER
NO. 22784

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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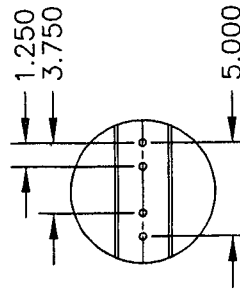




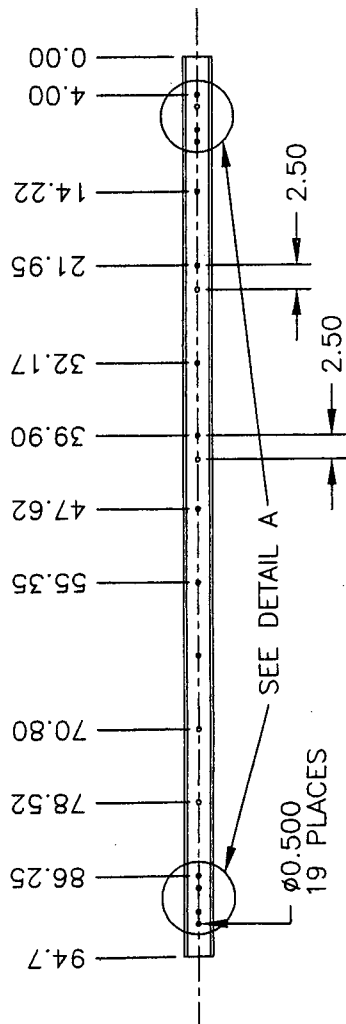
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB		SCALE 1:20

RELEASED
04.06.22

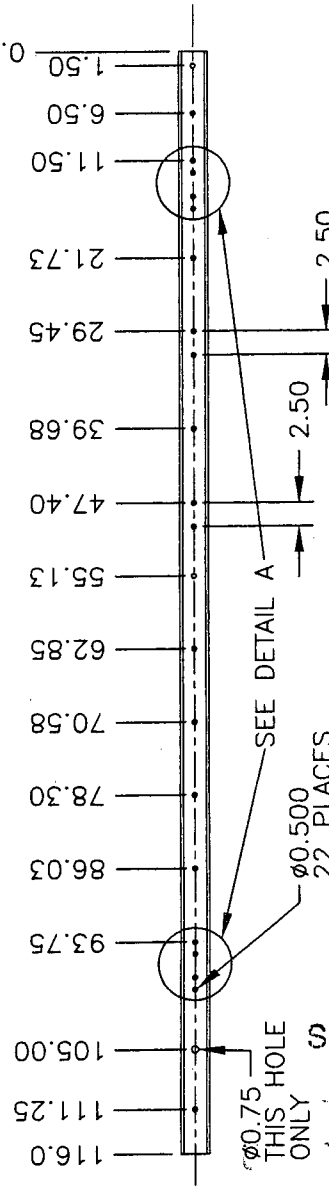
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
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WORK ORDER
NO. 22784

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 21, 2005
10:23 am

Work Order No : 0022784
Project Name : D2654-7
Project For : WK512
Work Order Type : Main
Main WO Number :
House Part Number : D2654-7
Description : 206 I Beam (Web)
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 03-18-05
Est Finish Date : 03-25-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00